

# Work Order ID 73715

Wednesday, September 14, 2011 8:57:54 AM



Page 1

Item ID:	D2221	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	350 Basket Base					
Start Date:	9/14/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	9/23/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2221	Rev H

100		0.00							
	Large Fab								
Large Fab		0.00							
Large Fab	Memo								

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221  
 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221  
 3- tack weld mesh on basket as per dwg D2221  
 A/R ER316 S.S. Rod Batch: 117884

\*\*\*PLEASE NOTE\*\*\*  
 IF MAKING -041A OR -043A :  
 DRILL HOLES FOR GAS SPRING  
 IN D3825-041 AS PER  
 DSI 9473

QC 11.09.15

110		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
QC		0.00							
Quality Control	Memo								

QC 11.09.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73715**

Wednesday, September 14, 2011 8:57:54 AM



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Item ID: D2221

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 9/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Sulall6

ⓧ

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

KØ M-Lu/09/19

W/O:		WORK ORDER CHANGES					
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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
	Powdercoat								
Powder Coating	Memo	0.00							
	1- Plug holes prior to								
	1ST COAT: 2:45								
	START TIME: 400 OF								
	OVEN TEMPERATURE:								
	FINISH TIME: 3:45								
	***** and coat if necessary*****								
	2ND COAT:								
	START TIME:								
	OVEN TEMPERATURE:								
	FINISH TIME:								
140	QC3- Inspect Part Finish	0.00							
	QC								
Quality Control	Memo	0.00							

*Handwritten signature: H. M. 11/09/14*

*Handwritten signature: D. B. 11-9-20*

*Handwritten: M118439*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Setup Start



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Item Name: 350 Basket Base

Stop



Start Date: 9/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Identify as per dwg & Stock Location: *GA*

0.00



Packaging

Memo

*w/o  
73713*

0.00

Packaging

*9/11/09/20* *(1)*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/9/20* *(J)*

*MF*  
*11-09-20*

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Page 1

**Parent Item Name:** 350 Basket Base

**Required Date:** 9/23/2011

**Required Qty: 1.00**

**Comments:** IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM  
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC  
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N  
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 		Manufactured	No			100	Each	17.0000	1	1		Pl 11.09.15	
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				17					
				71372				5		①			
				72297				12					
D2221-5 		Manufactured	No			100	Each	14.0000	2	2		Pl 11.09.15	
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				12					
				71218				12		②			
				WA006				2					
				67117				2					
D2221-7 		Manufactured	No			100	Each	9.0000	1	1		Pl 11.09.15	
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				5					
				71219				1					
				73203				4					
				WA006				4					
				72731				4		①			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 73715

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 9/14/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00

D2232-3  
Basket Hinge  
Manufactured No

100 Each 9.0000 2



2  
9/11.09.15

Location

Loc Qty

Loc Code

ST

9

72929

9

D2235-1  
Basket Rib  
Manufactured No

100 Each 14.0000 2



2  
9/11.09.15

Location

Loc Qty

Loc Code

WA

10

73202

10

WA005

4

66895

4

D2581  
Mounting Bracket  
Manufactured No

100 Each 44.0000 2



2  
9/11.09.15

Location

Loc Qty

Loc Code

WA

44

69258

7

69739

2

70766

2

73079

33

D3442-1  
Shim  
Manufactured No

100 Each 21.0000 2



2  
9/11.09.15

Location

Loc Qty

Loc Code

WA

21

71224

4

71783

17

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, September 14, 2011 8:57:51 AM

Work Order ID: 73715

Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 9/14/2011



Required Date: 9/23/2011

Start Qty: 1.00



Required Qty: 1.00

D3825-041      Manufactured      No      100      Each      8.0000      2  
            Pl 11.09.15  
 Rib Assembly (Basket End)



Location	Loc Qty	Loc Code
WA	2	
72080	2	
WA006	6	
72727	6	

D3826-041      Manufactured      No      100      Each      8.0000      2  
            Pl 11.09.15  
 Rib / Gusset Assembly

Location	Loc Qty	Loc Code
WA	8	
71805	2	
72728	6	

D3827-041      Manufactured      No      100      Each      10.0000      1  
            Pl 11.09.15  
 Rib Assembly (Inboard)

Location	Loc Qty	Loc Code
WA	10	
72083	4	
72729	6	

D3832-1      Manufactured      No      100      Each      3.0000      1  
            Pl 11.09.15  
 Mesh (Base)

Location	Loc Qty	Loc Code
WA	3	
72702	3	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

Wednesday, September 14, 2011 8:57:51 AM

Work Order ID: 73715



Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 9/14/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100 Each

16.0000

2



Mesh (Base End Face)



2  
9/14/09.15

Location

Loc Qty

Loc Code

WA

16

70470

6

71834

1

72866

9

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

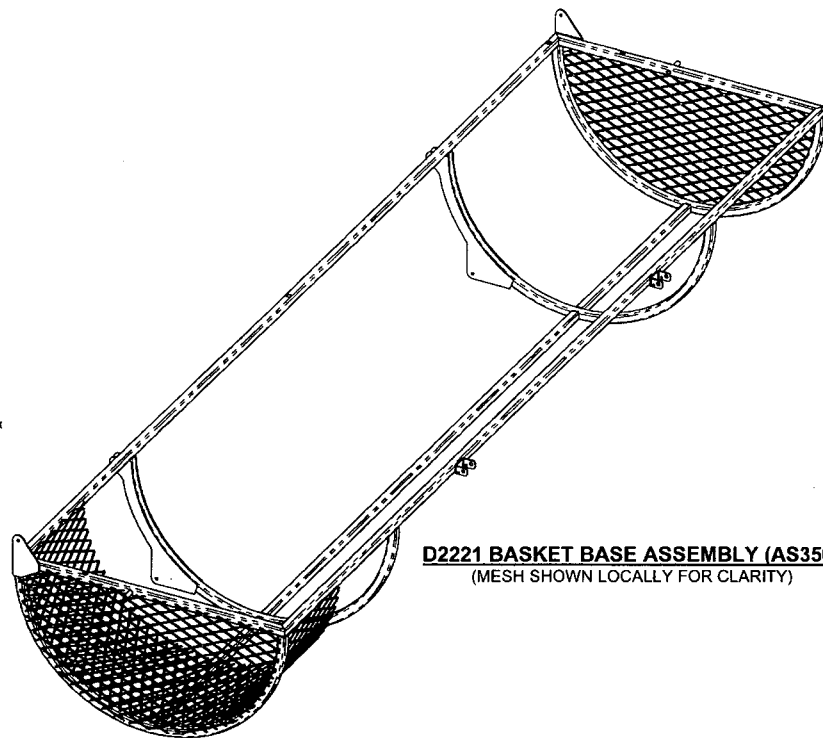
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 42.00 lbs APPROX
- 8) MASK ALL HOLES PRIOR TO POWDER COATING



ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

**RELEASED**  
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +1.0 0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.05.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	BW	DRAWING NO.	REV. H
MFG. APPR.	BW	D2221	SHEET 1 OF 5
APPROVED	BW	TITLE	SCALE
DE APPR.	BW	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

*also 73715*

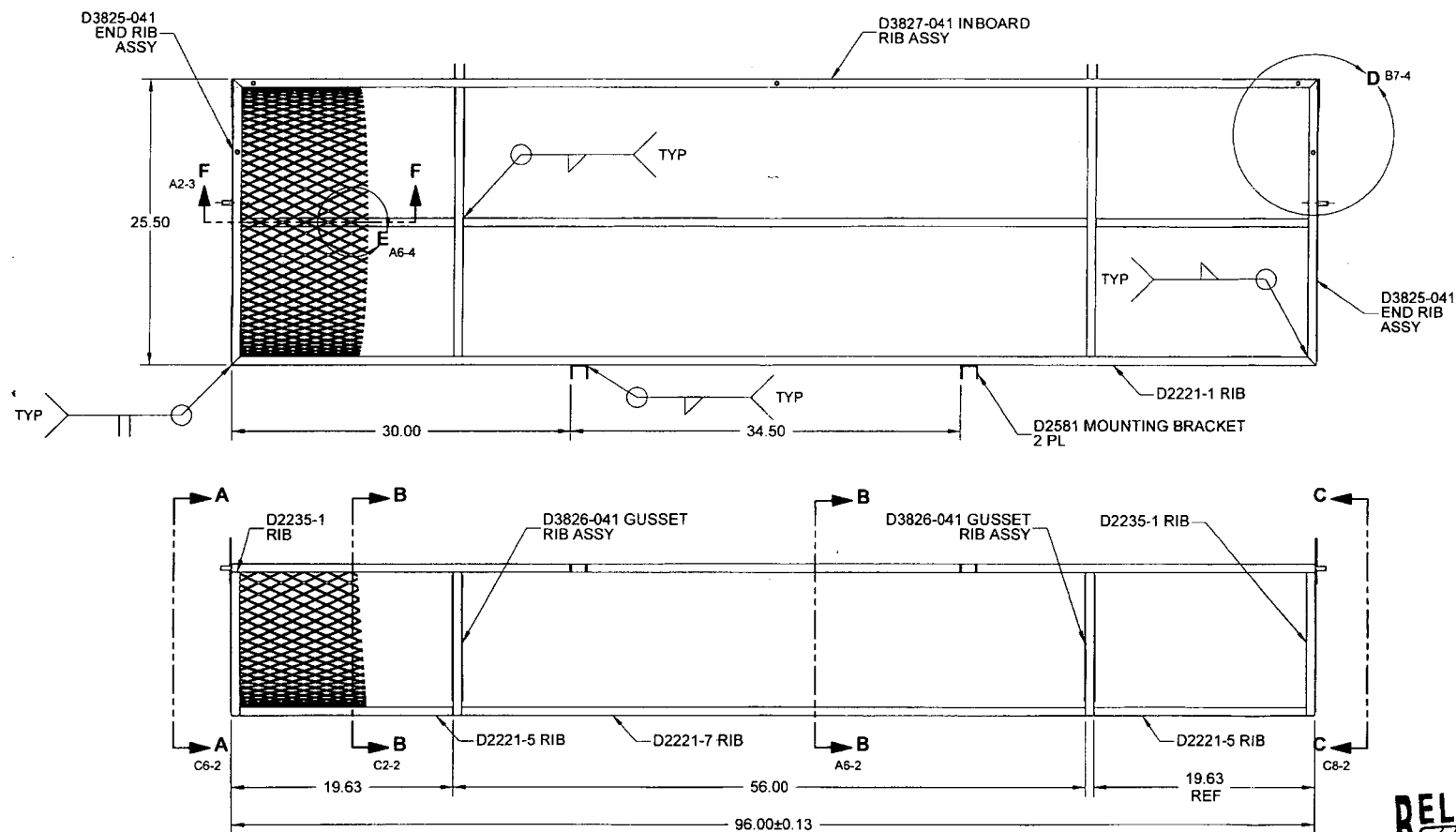
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**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

73715

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D2221</b>	REV. H
MFG. APPR.		TITLE	SCALE
APPROVED		<b>BASKET BASE ASSEMBLY (350) NTS</b>	
DE APPR.		COPYRIGHT © 1994 BY DART AEROSPACE LTD	
DATE	08.09.18	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

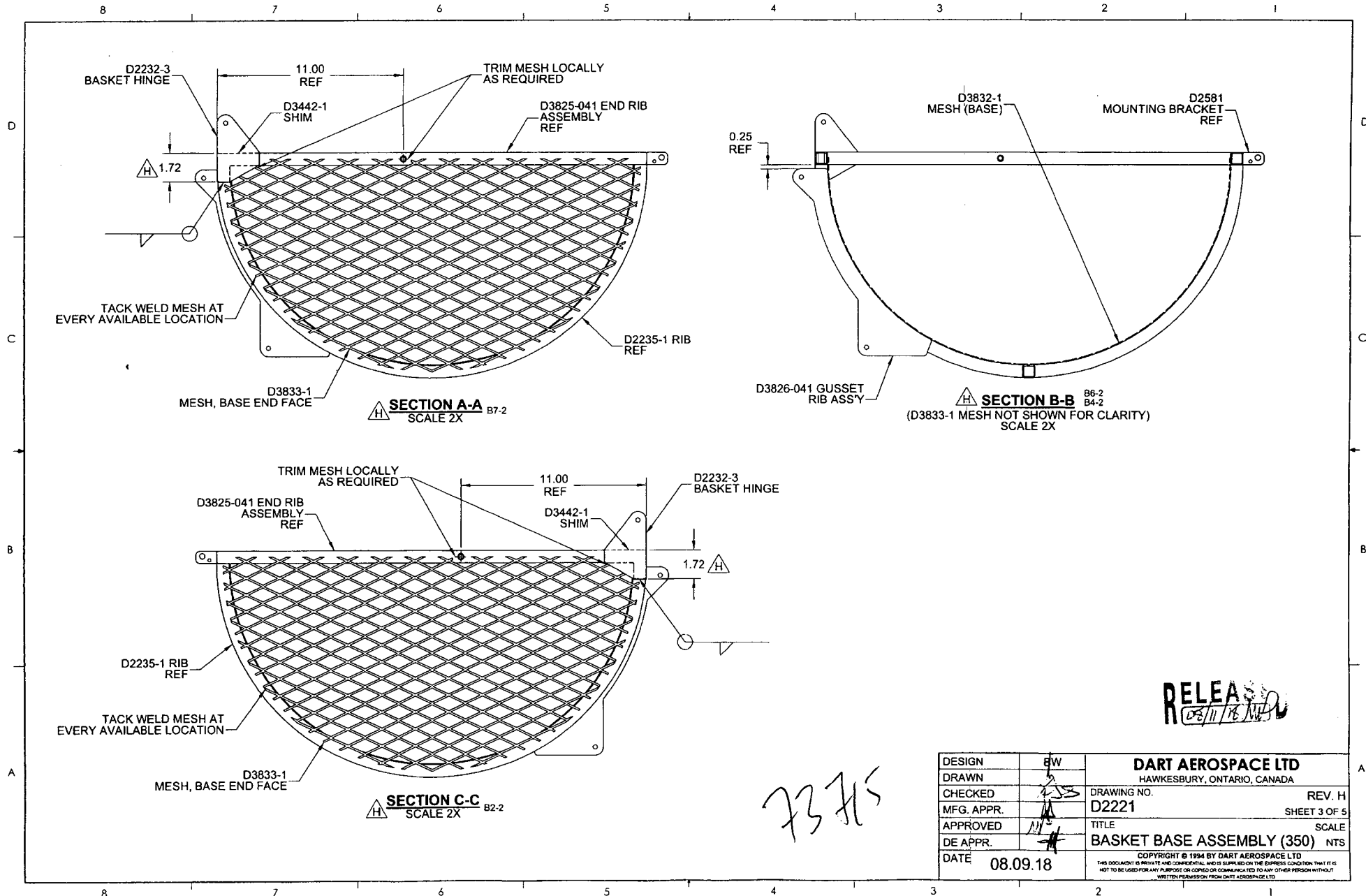
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RELEASED  
08/11/18

DESIGN	FW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	2		
CHECKED	233	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 3 OF 5
APPROVED	MS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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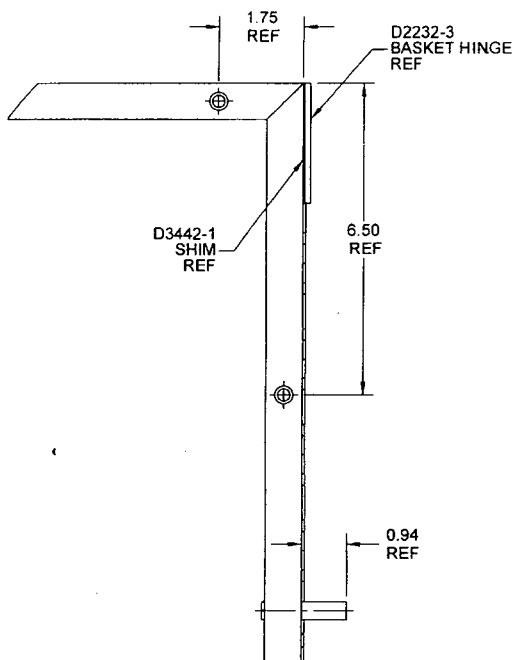
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8 7 6 5 4 3 2 1

D

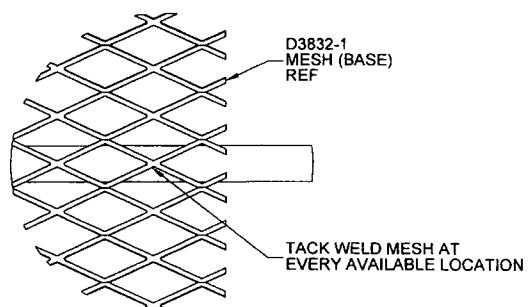


**DETAIL D**  
SCALE 4X D2-2

C

B

A



**DETAIL E**  
SCALE 4X C6-2

TRIM MESH AROUND  
BASKET STRUCTURE  
LOCALLY AS REQUIRED

TACK WELD MESH AT  
EVERY AVAILABLE LOCATION

D3832-1 MESH (BASE)  
FORM TO SUIT STRUCTURE  
ON ASSEMBLY

**SECTION F-F**  
SCALE 4X D7-2

**RELEASED**  
08/11/16

73715

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET BASE ASSEMBLY (350)</b>	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR COMMERCIAL TIES TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

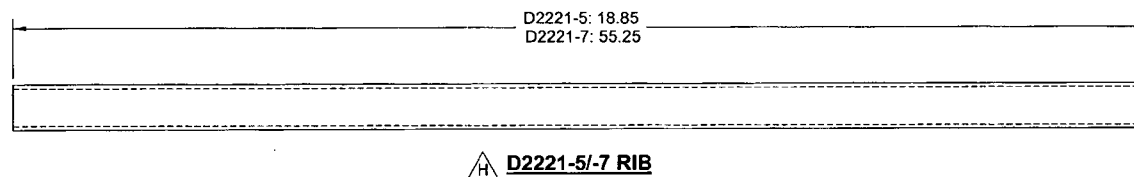
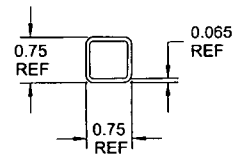
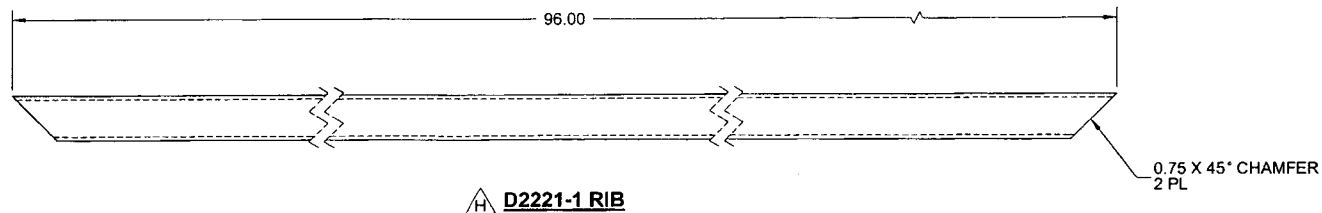
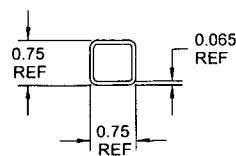
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





RELEASED  
06/11/18

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

73715

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ADS	DRAWING NO.	REV. H
MFG. APPR.	MO	D2221	SHEET 5 OF 5
APPROVED	MH	TITLE	SCALE
DE APPR.		<b>BASKET BASE ASSEMBLY (350)</b>	
DATE	08.09.18	NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries